



ITEM 94101 **Pipe Thread Kit**

(5 Piece Set - 3 Dies)

Assembly and Operating Instructions



3491 Mission Oaks Blvd., Camarillo, CA 93011

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For technical questions and replacement parts, please call 1-800-444-3353

Specifications

Kit includes Ratchet Head with Coupler, 2 Handles, 3 Dies, and Blowmold Case
Die Sizes: 1/2" (14 TPI); 3/4" (14 TPI); 1" (11.5 TPI)
Ratchet Head is Reversible; Dies Are Replaceable

Save This Manual

You will need the manual for the safety warnings and precautions, assembly instructions, operating and maintenance procedures, parts list and diagram. Keep your invoice with this manual. Write the invoice number on the manual for safekeeping. Keep the manual and invoice in a safe and dry place for future reference.

Safety Warnings and Precautions

WARNING: When using tool, basic safety precautions should always be followed to reduce the risk of personal injury and damage to equipment.

Read all instructions before using this tool!

1. **Keep work area clean.** Cluttered areas invite injuries.
2. **Observe work area conditions.** Do not use machines or power tools in damp or wet locations. Don't expose to rain. Keep work area well lighted. Do not use electrically powered tools in the presence of flammable gases or liquids.
3. **Keep children away.** Children must never be allowed in the work area. Do not let them handle machines, tools, or extension cords.
4. **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
5. **Do not force tool.** It will do the job better and more safely at the rate for which it was intended. Do not use inappropriate attachments in an attempt to exceed the tool capacity.
6. **Use the right tool for the job.** Do not attempt to force a small tool or attachment to do the work of a larger industrial tool. Do not use a tool for a purpose for which it was not intended.
7. **Dress properly.** Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, electrically nonconductive clothes and nonskid footwear are recommended when working. Wear restrictive hair covering to contain long hair.
8. **Use eye and ear protection.** Always wear ANSI approved impact safety goggles. Wear a full face shield if you are producing metal filings or wood chips. Wear an ANSI approved dust mask or respirator when working around metal, wood, and chemical dusts and mists.
9. **Do not overreach.** Keep proper footing and balance at all times. Do not reach over or across running machines.
10. **Maintain tools with care.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Inspect tool cords periodically and, if damaged, have them repaired by an authorized technician. The handles must be kept clean, dry, and free from oil and grease at all times.
11. **Stay alert.** Watch what you are doing, use common sense. Do not operate any tool when you are tired.
12. **Check for damaged parts.** Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment and binding of moving parts; any broken parts or mounting fixtures; and any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician.

13. **Guard against electric shock.** Prevent body contact with grounded surfaces such as pipes, radiators, ranges, and refrigerator enclosures.
14. **Replacement parts and accessories.** When servicing, use only identical replacement parts. Use of any other parts will void the warranty. Only use accessories intended for use with this tool. Approved accessories are available from Harbor Freight Tools.
15. **Do not operate tool if under the influence of alcohol or drugs.** Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.

Unpacking

When unpacking, check to make sure that all parts and accessories are included and in good condition. If any parts are missing or broken, please call Harbor Freight Tools at the number on the cover of this manual as soon as possible.

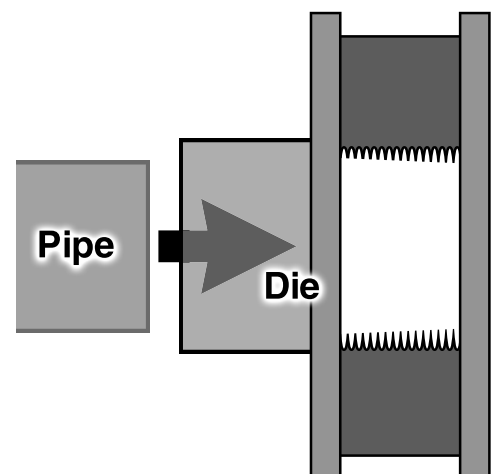
Preparation for Pipe Threading

1. Assemble the Handle parts (18 and 20) and insert threaded portion of Handle (18) into Ratchet Holder (8).
2. Determine the size of the pipe to be threaded.
3. Pick the appropriate die to be used. Die sizes are stamped on the outside of each die.
4. Insert the die into the Ratchet Holder. It is a force fitting, and once the die is in the Ratchet Holder, it may require light tapping with a wooden mallet to remove the die.
5. Have an oil can available to be used during the threading operation.
6. The pipe to be threaded must be properly secured during the threading operation.
7. To reverse the threading direction, pull out the reversing knob, turn it 180 degrees until the arrow points in the opposite direction and drop it back into place.

Operation

Now that the proper die is installed, you are ready to attach the Ratchet Holder to the pipe, and begin cutting threads.

1. Place the rear of the die over the end of the pipe to be threaded. Verify that the inside diameter of the die matches the outside diameter of the pipe.
2. Make sure that the pipe to be threaded is properly held in place.



Operation (continued)

Caution: Make sure the pipe end and threads of the die are sufficiently oiled at all times. Otherwise, die life will be shortened and the threads will be rough.

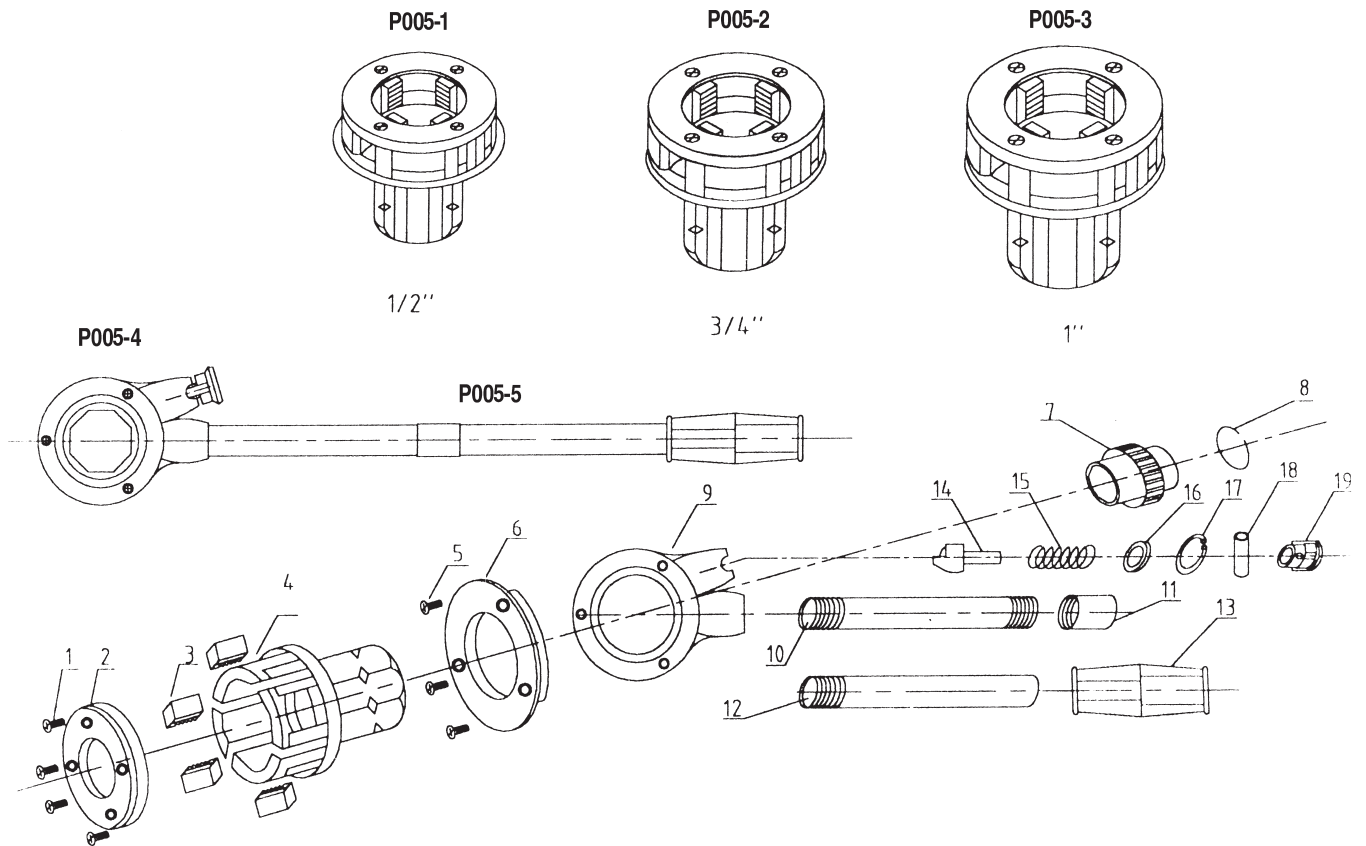
3. While applying pressure to the end of the pipe, begin rotating the Handle around the pipe to engage the die to the pipe end. Continue this operation until the desired thread length is achieved.
4. To disengage the Ratchet Holder after threading is complete, follow steps discussed in #7 on prior page to reverse the direction, and then rotate the Handle until the die is disengaged from the pipe end.
5. When sliding the pipe out of the Ratchet Holder, be careful not to damage newly cut threads.

Maintenance

1. Clean the Pipe Threading tool after each use. Clean dies after each use. Check for broken teeth or pipe material between teeth.
2. When not in use, store all parts in the case, and store the case in a dry location.

PARTS LIST

PART NO.	DESCRIPTION	Q'TY	PART NO.	DESCRIPTION	Q'TY
P005-1	DIE'S THREADER 1/2"	1	9	RATCHET HOLDER	1
P005-2	DIE'S THREADER 3/4"	1	10	CONNECTING ROD	1
P005-3	DIE'S THREADER 1"	1	11	ROD CONNECTOR	1
P005-4	DIE'S FRAME	1	12	ROD	1
P005-5	WORK HANDLE	1	13	PLASTIC HANDLE	1
1	SCREW	4	14	PAWL	1
2	COVER	1	15	PRESS SPRING	1
3	DIES	4	16	TIGHTENING RING	1
4	DIES HEAD	1	17	RETAINING RING	1
5	SCREW	3	18	SPRING BOLT	1
6	PLASTIC RING	1	19	KNOB	1
7	RATCHET	1			
8	STEEL RETAINING RING	1			





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LIMITED 90 DAY WARRANTY

Harbor Freight Tools Co. makes every effort to assure that its products meet high quality and durability standards, and warrants to the original purchaser that this product is free from defects in materials and workmanship for the period of 90 days from the date of purchase. This warranty does not apply to damage due directly or indirectly, to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities, or to lack of maintenance. We shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our product. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation of exclusion may not apply to you. **THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.**

To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

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